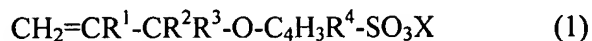


CLAIMS

1. An article comprising a skin formed from a water soluble resin, wherein the resin comprises a water-soluble polymer and a water-soluble filler.
2. An article as claimed in claim 1 wherein the water soluble polymer preferably comprises 20-90wt% of the resin, more preferably from 25-85wt%, more preferably from 30-80wt%, more preferably from 35-80wt% more preferably from 40-80wt%, more preferably from 45-80wt% and most preferably from 50-80wt%.
3. An article as claimed in claim 1 or 2 wherein the water soluble polymer comprises a film forming polymer.
4. An article as claimed in any one of claims 1 to 3, wherein the water soluble polymer comprises polyvinyl alcohol, polyvinyl pyrrolidone, partially hydrolysed polyvinyl acetate, polyvinyl acetate, a cellulose polymer (such as a cellulose ether e.g. hydroxypropyl cellulose), a copolymer / a derivative thereof or a mixture thereof.
5. An article as claimed in any one of claims 1 to 4, wherein the water soluble polymer comprises a polymeric polycarboxylic acid, a polycarboxylate or a salt thereof.
6. An article as claimed in any one of claims 1 to 3, wherein the water soluble polymer comprises a sulphonated polymer.

7. An article as claimed in claim 6, wherein the sulphonated polymer is based upon the monomer of Formula (1):



wherein R^1 , R^2 , R^3 , R^4 are independently 1 to 6 carbon alkyl or hydrogen, and X is hydrogen or alkali; homopolymerised or copolymerised with one or more of acrylic, fumaric, maleic, itaconic, aconitic, mesaconic, citraconic and methylenemalononic acids or their salts, maleic anhydride, acrylamide, alkylene, vinylmethyl ether, styrene or a mixture thereof.

8. An article as claimed in any one of claims 1 to 3, wherein the water soluble polymer comprises a polyamine.
9. An article as claimed in any one of claims 1 to 8, wherein the water soluble filler comprises at least 10wt% of the resin composition, more preferably at least 15wt%, more preferably at least 20wt%, more preferably at least 30wt%, more preferably at least 40wt% and most preferably at least 50wt%.
10. An article as claimed in any one of claims 1 to 9, wherein the water soluble filler comprises a carbohydrate.
11. An article as claimed in claim 10, wherein the carbohydrate comprises glucose, dextrose, fructose, lactose, sucrose, maltose, a dextrin, a sugar alcohol, a water soluble starch derivative, a water soluble cellulose material or a mixture thereof.
12. An article as claimed in any one of claims 1 to 9, wherein the water soluble filler comprises an ionic sulphate salt.
13. An article as claimed in any one of claims 1 to 9, wherein the water soluble filler comprises an ionic silicate.

14. An article as claimed in any one of claims 1 to 9, wherein the water soluble filler comprises an oligomeric phosphate.
15. An article as claimed in any one of claims 1 to 14, wherein the water soluble filler has a detergent function.
16. An article as claimed in claim 15, wherein the filler comprises a builder and/or a surfactant.
17. An article as claimed in any one of claims 1 to 16, wherein the resin includes a lubricant and / or a plasticiser.
18. An article comprising a skin formed from a water soluble resin and a detergent composition, wherein the resin is in accordance with any one of claims 1 to 17.
19. A method of producing an article having a water-soluble or water dispersible skin, wherein the skin is formed in an injection moulding process using a water soluble resin in accordance with any one of claims 1 to 18.